

Work Order ID 134230

Wednesday, July 08, 2015 10:42:00 AM

134230

Page 1

Item ID: D2563

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Weldment Assembly

Start Date: 7/7/2015 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 7/17/2015 Req'd Qty: 4.00 *4*

Customer:

Reference: rework

Approvals: Process Plan: UMF Date: 15-7-20 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2563	Rev C								

230

0.00

230

QC

Quality Control

Memo

0.00

STEPS CAME BACK ON RA111987

STEPS NEED TOUCH UP POWDER COAT AND WING WALK BEFORE
GOING BACK INTO STOCK

D2563 x 4 B126064 UMF 15-7-8

④ 15-07-09 PD

240

0.00

240

HandFinish

Hand Finishing

Memo

0.00

TOUCH UP POWDER COAT AND WING WALK

Primer: 132122

Paint: 132664

WING WALK. m 132599

4 15-8-20

DAS

41

9-89

15-8-20

H 15-8-20. 888

DART			
PATENT	N/A		
P/N	D205-633-017	CHG	CHG001
DESC	Heli-Access-Step, LH/RH	SIC	SH96-57
LOT	B126835	SIC	SR00592/3NY
MODEL	Bell 205/210/212/214/412	SIC	SR00594NY
TO APPROVAL # 09-39 MADE IN CANADA			

DART			
PATENT	N/A		
P/N	D205-633-017	CHG	CHG001
DESC	Heli-Access-Step, LH/RH	SIC	SH96-57
LOT	B126835	SIC	SR00592/3NY
MODEL	Bell 205/210/212/214/412	SIC	SR00594NY
TO APPROVAL # 09-39 MADE IN CANADA			

DQA:

Date: 15/09/02

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only



Work Order: <u>134230</u> Part No. <u>D2563</u> NCR No.		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☒</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date: 15-08-14		Step #: 100		QTY Effective: 2		MRB (QSI042) Approval DAS 20 0-89 2015/08/12																																																																			
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Spray paint mask wing walk, scuff and re paint (spray paint) as per QSI 005.				2 out of 4 repainted Primer 132122 Paint 132664																																																																					
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								Lead hand / Supervisor Approval Verification DAS 38 9-89 AUG 20 2015																																																																	
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Wednesday, July 08, 2015 10:42:00 AM

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ML5 AUG 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Wednesday, July 08, 2015 10:41:59 AM

Page 1

Work Order ID: 134230

134230

Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 7/7/2015

Required Date: 7/17/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2563		Manufactured	No				Each	4.0000		4			

D2563

Step Weldment Assembly

Location

Loc Qty

Loc Code

FG

4

133313

4

4 x 126064

MF 15-7-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

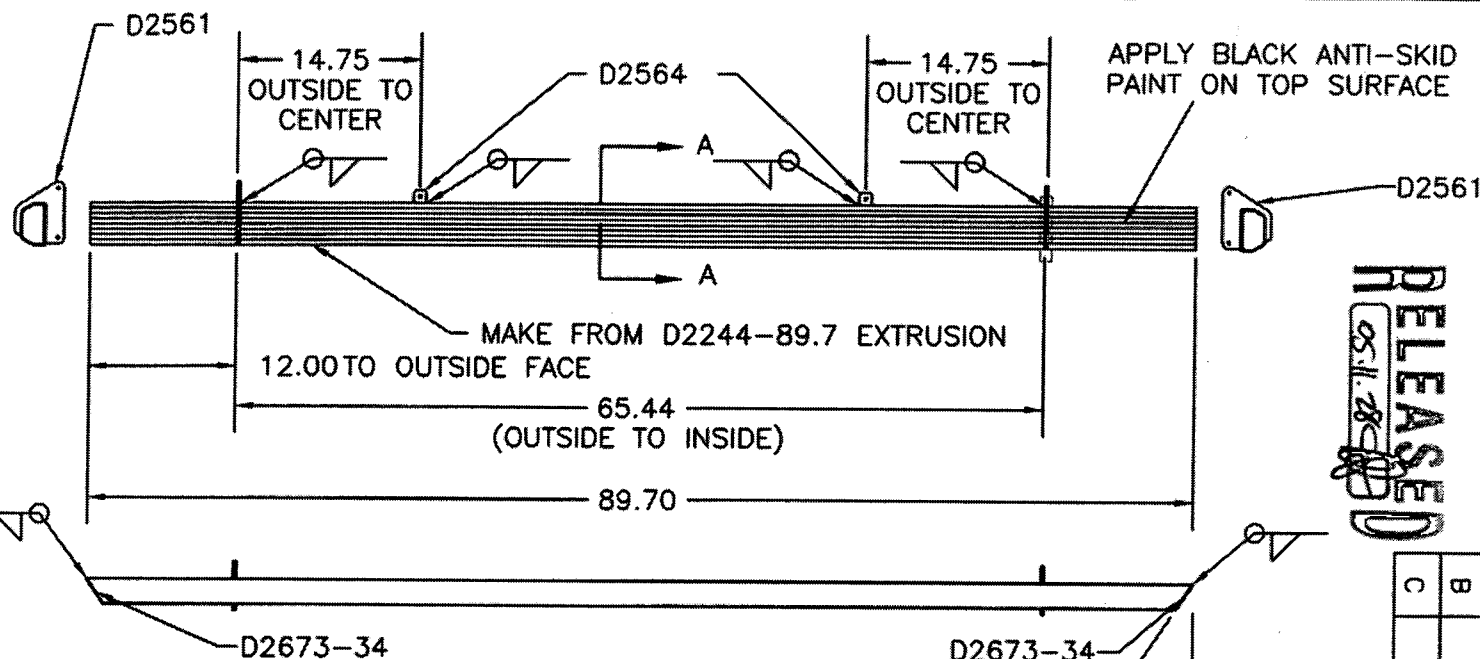
Work Order update only ☐

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Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____																							
Misidentified ☐	☐ Past Due																								



RELEASED
05.11.28

DESIGN	BW	DRAWN BY	H	DART AEROSPACE LTD
CHECKED	H	APPROVED	H	HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	TITLE	D2563	REV. C
			STEP WELDMENT ASSEMBLY	SHEET 1 OF 1
				SCALE 1:15
A	96.04.26	NEW ISSUE		
B	97.05.14	END CAPS CHANGED (WAS D2248)		
C	05.11.14	UPDATE NOTES		



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
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		OTHER : ☐							

RA111987

Received @ April 14, 2015
Inspected @ May 6, 2015

CUSTOMER: HAWKER PACIFIC-DUBAI
CUSTOMER CONTACT: MALCOLM COELHO
SHIPPED FROM: DUBAI

Instructions for RA111987 D205-633-017 B126835 CHG001

- Customer order wrong parts
- List of parts that was return with minor damage due to assembly by customer
 - D2563 B126064 4x
 - Create work order for touch up powder coat and wing walk on D2563 and return in stock new batch number-134230
 - D2562-007 B126899 1x / B126839 2x / B90311 1x - 134231
 - D2565-401 B126898 1x / B126836 1x / B118453 1x / B88300 1x - 134232
 - D2565-403 B124437 2x / B126840 1x / B118454 1x - 134233
 - D2565-405 B126837 1x / B118455 1x / B88305 2x - 134234
 - D2565-407 B126895 1x / B110372 2x / B118456 1x - 134235
 - D2565-409 B47831 4x - 134236
 - D2565-411 B118458 1x / B123943 2x / B126838 1x - 134237
 - Create work order to strip and powder coat all D2565 and return in stock with new batch number
- List of parts that was not return
 - AN4-14A 1x
 - AN4-5A 2x
 - AN4-6A 2x
 - AN4-7A 2x
 - AN5-14 1x
 - AN5-6A 1x
 - D2021-101 1x
 - D2022-101 2x
 - D2022-103 2x
 - MS21042L4 8x
 - MS21042L5 2x
 - NAS1149D0463J 15x
 - NAS1149D0563J 4x

Time Estimate: 8 hours

Departments Required: quality, finishing, stores

Pictures Attached: N/A

QTY INSPECTED: 4x D205-633-017 B126835 CHG001

**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								